Work Orde 1004-27-13 12:4		20		*102	220*					Page 1		
Revision ID:	D4046-3			Accept	*N900	040	100)* s	etup Start Stop	10'2 i		
tem Name:	Mesh Fwd End							•	Stop	*NS2*		
start Date:		Start Qty: 2.00	*2*		Cust Item	ID:						
Required Date: : Reference:	5/27/13 F	Req'd Qty: 2.00	*2*		Customer:	•						
Approvals:	Process Plan	MLJ	Date: 13-05-30	Taoling:		ate:		R	tun Start	*NR1*		
tppi ovais.		pic.				ate:			Stop	*NR2*		
Sequence ID/ Work Center ID		peration escription		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp		
Draw Nbr	Revisio	on Nbr										
D4046	A											
00				0.00	 - 							
100	F	LOW WATER JET						2	0	JM13-07	-03	
Waterjet		Memo		0.00								
FLOW CNC Waterje	et .	1-Cut as per Dwg Rev: Prog Rev: 2-Deburr if i	A									
110	Q	C2- Inspect parts off m	nachine FAI/FAIB	0.00								
*11 0 *								2	ક	JmB-c	0-FC	
QC		Memo		0.00								
Quality Control										. *		
¹²⁰ *120*	Ç	C8- Inspect parts - seco	ond check	0.00 DAS	3100 ln			(2 2)				
QC		Memo		0.00 9-89	フロレン					\ .		

Quality Control

NCR:	Yes	1	Nο

DQA:

Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
									·	QA Closed:	Date:	
Work Ordei	÷:	-			DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
					Rework	7 	Skid-tube Crosstube			Water Jet		Engineering
Part N	0.				Scrap	1	ſ	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~~				Use-as-is	1 -	Therm	noforming	Finishing	Rec/Sto	e/Packaging	Other
NCR N	o				Work Order Update] [Large Fab Composite]	Supplier	
Root	T-	<u> </u>		Descri	ption of work order update	Ini	tial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance		f Eng		cription	Date	Verification	QC Inspector
Ooc/Data	- Butte	July	2.7	<u> </u>	0	1						
quip/Tooling												
perator	1 ·											
Material												
etup												
Other												
Process	\neg					İ						
Supplier												
raining [1										
Jnapproved												
						FAULT	CATE	GORY				
Landin	g Gear			_	General					7		· ·
	Bending			_	Bend	ШG	irain			Ovalized	<u> </u>	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	—	lardwa			Over/Under		Temperature/Cure
ļ	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorre	 	Weld
]		/Crimped			Burrs			ions Incomplete	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	\vdash		enance	<u>_</u>	Part Moved		
ļ	Heat Tre	at		L	Countersink	—	/lislabe			Positioned V	_	7
ļ	Inspection	•	Tube		Cut Too Short	-	⁄lisreac	t		Power Loss/	Surge	Other
	Ripples i				Drill Holes	-	Offset					
Ĺ	Torque \	Vaves in	Extrusio	n L	Drawing			Calibration				
	Turning	Sequence	!		Finish	\vdash		Sequence				
Wave/Twist in Tube					Folio	c	Outside	Dimensions				

Work Ord <i>May-27-13</i> 12.		02220		<u></u>	Page 2			
Item ID: Revision ID:	D4046-3			Accept	*N90004010	O* Setup	Start Stop	*NS1*
Item Name: Start Date: Required Date Reference:	Mesh Fwd I 5/27/13 e: 5/27/13	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item ID: Customer:		эшр	*NS2*
Approvals:	Process I	Plan:	Date:		Date:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center	ID	Operation Description Identify as per dwg & St	tock Location: W	Set Up/ Run Hours	Tool ID Tool # Plan Code			Reject Insp. Number Stamp
130 Packaging Packaging		Memo		0.00	(p(13.7.18		<u>/</u>	
140 * 4 4 0 *		QC21- Final Inspection	- Work Order Release	0.00			13/	2/020
*14 ∩ *		Memo		0.00				1/10 /

Quality Control

plB.07-10

											DQA:	Date:	
NCR: Y	es /	No				WORK ORDER NON-C	ON	IFORN	MANCE / UP				
											QA Closed:	Date:	
Work Orde	rė.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
WOIK OIGE		-				Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	Quality	
						Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo					Work Order Update			Large Fab	Composite		Supplier	
Root		İ				ption of work order update		nitial		tion	Sign &	. <u>-</u>	
Cause		ate	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data	_												
Equip/Tooling							l					!	
Operator								1					
Material				-					·				
Setup									,				
Other													
Process						·							
Supplier													
Training													
Unapproved					<u> </u>						<u> </u>		
							AUL	T CATE	GORY				
Landi	ng Gea					General		۱			1		lo (5)
Bending Bend							\vdash	Grain		-	Ovalized		Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						-	Hardwa		_	Over/Under	 	Temperature/Cure
						Broken/Damaged	<u> </u>	1	ion Incomplete	<u> </u>	Part Incorre		Weld
Crushed/Crimped					<u> </u>	Burrs		1	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cu				<u> </u>	Contamination	<u> </u>	Mainte		<u> </u>	Part Moved		
	\vdash	at Trea			<u> </u>	Countersink	<u></u>	Mislabe			Positioned V		1
1	Inspection Strip in Tube					Cut Too Short	1	lMisread	d i	1	Power Loss/	Surge I	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

May-27-13 12:41:33 PM

Work Order ID:

102220

Parent Item:

D4046-3

Parent Item Name:

Mesh Fwd End

Start Date: 5/27/13

Required Date: 5/27/13

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 10/01/06 verified by:EC

verified by:EC

IPP Rev:B as per dwg revA DD 10.02.18

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F Expanded Metal Flat SS		Purchased	No			100	sf	1,289.8151	3.5414	7.45557 89 /O			JMB-07-09
·				Location		Loc Qty	<u>La</u>	oc Code					
				MAT		176.2791180				.			
					125113	176.279118							
				WA		414							
					125457	414							
				WA007		699.536							
					123448	15.96							
					125457	203.576							
					125605	480							
									127	~~~			

126052

126052

NCR:	Yes	/	No

DQA:

Date: ___

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE												
										QA Closed:	Date:	
Work Order					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
					Rework	1 l	S	kid-tube	Crosstube	7	Water Jet	Engineering
Part No	o.		i		Scrap	1	M	achining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is] Th	nermo	oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	o				Work Order Update]	Li	arge Fab	Composite		Supplier	
	1	T		.		1 1.24	-1	Α.	- A.T.	C: 0	1	
					ption of work order update	Initia			ction	Sign &	Verification	QC Inspector
Cause	Date	Step	Qty	•	or Non-conformance	Chief	Eng	Desc	cription	Date	vernication	QC IIIspector
oc/Data	\dashv										i e	
quip/Tooling Operator	-	i										
Material							- 1					
etup	1											
Other							1					
rocess												
Supplier												
raining	1										1	
Jnapproved	_									1		
<u> </u>						AULT C	ATEG	ORY				
Landin	g Gear				General							_
	Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Har	rdware	2		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Ins	pectio	n Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped	•		Burrs	Inst	tructio	ons Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Ma	ainten	ance		Part Moved		
	Heat Treat Countersink				Mis	slabele	ed	<u> </u> _	Positioned \		7	
	Inspection	n Strip in	Tube		Cut Too Short	\vdash	sread			Power Loss/	'Surge	Other
					Drill Holes	 	fset					
1	Torque V			ո _	Drawing	— —		libration				
ļ	Turning S				Finish	\vdash		quence				
Wave/Twist in Tube Folio						Ou	itside 🛭	Dimensions				

DART AEROSPACE LTD	Work Order:	102220
Description: Mesh Fwd End	Part Number:	D4046-3
Inspection Dwg: D4046 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension		Dimension	•		Inspection	,
24.00	+/-0.030	24.00"	_			JL-mo6
21.25	+/-0.030	21.25	_		L T	
11.06	+/-0.030	11.06"	-		V	Produtor
0.50	+/-0.030	0.50			V	Jamo (
4.00	+/-0.030	4.00			✓	
17.18	+/-0.030	17.18	-		7	
0.50	+/-0.030	0.50	-		V	
4.50	+/-0.030	4.50"			V	
4.35	+/-0.030	4.35"	_		V	
11.15	+/-0.030	11.15"	-		V	
14.80	+/-0.030	14.80"			T	

					191800000	
						*
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			-			
			,			

Measured by: Jr	n	Audited by:	OAS 16	Prototype Approval:	N/A
Date: 13	20-F0-3	Date:	9-83 1360/43	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	10.04.01	New Issue	KJ 9	
			'()	7-7-

